Work Order ID 120028 June-03-14 7:12:01 AM	*120	N28*				Page 1
Item ID: D3391-025  Revision ID: Item Name: Aft Tube Assembly  Start Date: 6/03/14 Start Qty: 1.00	Accept	*N900040 Cust Item ID:	100*	Setup S	· · · · · · · · · · · · · · · · · · ·	IS1* IS2*
	*1*	Customer:			<b>~</b>	
	OGOZ         Tooling:           SPC (Y/N):	Date:	·		Ston	IR1* IR2*
Sequence ID/ Operation Work Center ID Description	Set Up/ Run Hours	Tool ID Tool #	Plan Acc Code Qty	ept Rejec		Insp. Stamp
Draw Nbr Revision Nbr					· ·	÷
Mori Seiki CNC Lathe Large Turn as per Folio FA599	0.00		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	1 4	· ·	14/08/11/
QC2- Inspect parts off machine FAI/FA  *110* QC Memo Quality Control		٧ .*	<u>.</u>	Lφ	· 	
QC5- Inspect part completeness to step	on W/O 0.00	e god		(D)  V	109.25	DAS 9 9-89

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DQA:			Date:											DART
QA Closed:			Date:			WORK ORDER NON	I-C(	ONFO	RMANCE / UP		ork Order up	date only	$\overline{}$	AEROSPACE
QA Closed.			Date.								<u> </u>			,
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	•					Rework	7 l		Skid-tube	Crosstube	]	Water Jet		Engineering
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	Cuffs Crimp/Kink/Ripple/Wave			•		Contamination		1 '	ions Incomplete/U	·	Part Moved	-	П	Wrong Stock Pulled
	Crushing					Countersink		4	ned/off center		Positioned V	Vrong		
	Heat Treat					Cut Too Short		Mislabe			Power Loss/	Surge		Other
	Inspection Strip in Tube			Tube		Drawing		Misread	d į					
	Marks/Chatter					Drill Holes		Off-set	•					
		Turning S	equence			Finish		Out of 0	Calibration					
		Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence					•

Work Ord June-03-14 7:1		20028		*120	<b>0028</b> *						Page 2
Item ID: Revision ID: Item Name:	D3391-025			Accept	*N900	ი4ი	100	)*	Setup Sta	17	S1* S2*
Start Date: Required Date: Reference:	6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				· N	5/"
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		nte:			Run Sta	" ^I <i>V</i> I	R1* R2*
Sequence ID/ Work Center II 120 *120 HAAS 1 HAAS 1		Operation Description  HAAS CNC VERTICAL  Memo  1-Machine a 2-Deburr	MACHINING #1 s per Folio FA 599 Rev	Set Up/ Run Hours 0.00 0.00 & Dwg D3391 Rev	Tool ID	Tool#	Plan Code	Accept	Reject Qty	Reject Number	Insp. Stamp
*1.20* QC: Quality Control		QC2- Inspect parts off many Memo	achine FAI/FAIB	0.00	JII Jii	12		_ }			-
<sup>140</sup> <b>*1⊿∩*</b> OC		QC8- Inspect parts - seco	nd check	0.00	,			<u> </u>	Ø		DAS 44  4  0

\*\*\*INSPECT INSIDE BORE\*\*\*

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	Heat Treat				Cut Too Short		Mislabe	eled		Power Loss/	Surge	(	Other	
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	Turning Sequence					Finish		Out of	Calibration					
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence						

<b>Work Ord</b> June-03-14 7:12		0028		*1200	N28*							Page 3
Revision ID:	D3391-025 Aft Tube Asse	ambly		Accept	*N900	<b>040</b>	100	ገ*	Setup	Start Stop	I A	S1*
	6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	D:				•	^1\\	S2*
Approvals: Process Pla QC:		nn:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
*150* Skidtubes		Skidtubes  Memo  1-Drill ( PILO	OT HOLE) aft cap holes	0.00 per Dwg D3391 using DT880	03			/		0	14-10.	14 DEC
160 <b>*160*</b> CNC Bend 1 CNC Delta 100 Bend	ler	BENDING MACHINE - :  Memo Form as per I	SKIDTUBES Dwg D3391 Using Bend	0.00 0.00 Prog 3391025				_/	_ #	<u>5</u> .	14-/6	0-15//
170 <b>*17</b> 0* QC		QC5- Inspect part comple  Memo	teness to step on W/O	0.00			DAS 03 9-89		D	<u>'</u> 4-	-10-1	().! 1 <del>5</del>

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						DISPOSITION	ON					AGAINST D	EPARTMENT	/PROCESS	
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. Dami \$							ework			Skid-tube Machinin		Crosstube Small Fab	- Bro	d. Eng. Coor.	Engineering Quality
Part N	NO						Scrap e-as-is			noforminរ	<b>-</b>	Finishing	<b>→</b>	re/Packaging	Other
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Cause	. ],	, <sup>7</sup> Date	Step	Qty		or non-conforman		Ch	ief Eng		Desci	ription	Date	Verification	QC Inspector
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	Heat Treat Cut Too Short							$\vdash$	Mislab	_	<del></del> -	<u> </u>	Power Loss,		Other
	Inspection Strip in Tube Drawing						•		Misrea			L		~ <u>_</u>	
	Marks/Chatter Drill Holes								Off-set				· · · · · · · · · · · · · · · · · · ·		
	Ь—	Turning S				Finish			4	Calibration	ŀ				
[	-	Wave/Tw				Fit/Function			Out of	Sequence					

Page 4

Insp.

Stamp

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

8- Scribe batch # on fwd end

7-Deburr

DQA:			Date:										TRAGE
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,5	-	<del></del>			-	Rework	1		Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo.					Scrap	1		<b>—</b>	nall Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	Thern	noforming F	inishing	Rec/Stor	e/Packaging	Other
NCR N	۱o.					Suspected Unapproved	]		Large Fab Cor	mposite		Supplier	
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	Crimp/Kink/Ripple/Wave			/Wave		Burrs		4	ion Incomplete/Unquali		Part Lost/Mi	ssing	Weld
	Cuffs				L	Contamination	L	4	tions Incomplete/Unclea	ar	Part Moved	L	Wrong Stock Pulled
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	Turning Sequence					Finish		4	Calibration				
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Work Ord		20028		*120	<b>1</b> 028*				Page 5
Item ID: Revision ID:	D3391-025	5		Accept	*N900040	100*	Setup		*NS1*
Item Name:	Aft Tube As	ssembly						Stop	*NS2*
Start Date:	6/03/14	Start Qty: 1.00	*1*		Cust Item ID:				
Required Date Reference:	e: 6/03/14	<b>Req'd Qty:</b> 1.00	*1*		Customer:				
Approvals:	Process P	Plan:	Date:	Tooling:	Date:		Run	Start	*NR1*
	QC:		Date:	_ SPC (Y/N):	Date:			Stop	*NR2*
Sequence ID/ Work Center l	ID	Operation Description	<u>y</u>	Set Up/ Run Hours		Plan Acc Code Qty			Reject Insp.
190		QC5- Inspect part compl	eteness to step on W/O	0.00		DAS C	( )		
*1 QN* QC Quality Control		Мето		0.00		989		14	1-10-16
200		Chemical Conversion Co	pat per QSI005 4.1	0.00	· · · · · · · · · · · · · · · · · · ·		 <del>\</del>		
*200*							) /	[4]-,	10-17////
HandFinish		Memo		0.00	,	$\bigcirc$			1
Hand Finishing		•							
<sup>210</sup>		QC7-Inspect Chemical C	Conversion Coat	0.00				i / 1	-10-70
QC		Memo		0.00		<i>\\</i>	+	14	10-60

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			_		_	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
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		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost/M	issing	Weld
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		Wave/Twist in Tube				Fit/Function		Out of	Sequence				

Work Orde June-03-14 7:1		0028		*120	<b>1028*</b>					_	•	Page	6
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube Asse	embly		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
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Sequence ID/ Work Center II 220 *20 *20 *Skidtubes Skidtubes	<b>D</b>	A/R Magna exp. date:	using #9 drill	Set Up/ Run Hours 0.00	Tool ID	Tool#	Code	Accept Qty	Qty	y I	Reject Number	Insp. Stamp	
230 <b>*230</b> QC		QC5- Inspect part comple	eteness to step on W/O	0.00					14	.102K	>	D	

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						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UF	PDATE		_		AEROSPACE
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Work Orde						DISPOSITION		:		AGAINST DE	EPARTMENT,	/PROCESS		
WOIK OIGE	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	$\neg$	Engineering
Part N	lo.					Scrap	1	ŀ	Machining	Small Fab	Pro	d. Eng. Coor.	1	Quality
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-	Crimp/Kink/Ripple/Wave			/Wave	$\vdash$	Burrs	-	4 '-	ion Incomplete/Un	<del></del>	Part Lost/M	issing	—	Weld
	Cuffs				-	Contamination	_	4	tions Incomplete/U	Inclear	Part Moved	Munna	v	Wrong Stock Pulled
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	- 1	Wave/Tw	rist in Tub	e.	1	Fit/Function	1	jout of 3	sequence					

Work Orde June-03-14 7:1		120028		*120	<b>)</b> の28*					]	Page 7
Item ID: Revision ID:	D3391-0			Accept	*N9000	<u>14010</u>	)O*	Setup	Start Stop	*NS1	*
Item Name: Start Date: Required Date: Reference:	Aft Tube . 6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	<b>)</b> :			Stop	*NS2	) <del>*</del>
Approvals:	Process QC:		Date:	Tooling: SPC (Y/N):	Dat Dat			Run	Start Stop	*NR1	)*
Sequence ID/ Work Center II 235 *25* HandFinish Hand Finishing	D	Operation Description Pressure Wash per QSI00  Memo AND REAL	O5 4.3 ODINE AS PER PARO	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool # Plan Cod		pt Rej Qty		Reject Insp Number Stan	
240  *240  *DAN* Powdercoat  Powder Coating		White Gloss(Ref:4.3.5.1)  Memo START TIM OVEN TEM FINISH TIM	808 · ie: <u>3:00</u> iperature: <u>32</u>	0.00 0.00			1	<i>\sqrt</i>	<u>                                      </u>	<u>V-12.</u>	DAS 34
250 *0 <b>50</b> *		QC3- Inspect Part Finish		0.00			١.,	$\int$	HD	(	111-

W. S.

0.00

Memo

DQA:			Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / U				AEROSPACE		
QA Closed:			Date:							V	Vork Order up	date only			
Work Orde	er:					DISPOSITION		1		AGAINST D	EPARTMENT	PROCESS			
Part N	اo،					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root	_				Desc	ription of work order update		nitial	Δα	ction	Sign &				
Cause		Date	Step	Qty	Desci	or non-conformance	1	ief Eng		cription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
					*		FAI	ULT CAT	regory						
Landi	ng (	Gear				General									
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing					Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center			Outside Dim Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V	tolerance ci ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled		
	Crushing Heat Treat		$\vdash$	Cut Too Short		Mislabe		ŀ	Power Loss/		Other				
	Inspection Strip in Tube			Drawing		Misread			·						
,	$\vdash$	Marks/Ch	-			Drill Holes		Off-set							
,		Turning S				Finish		Out of	Calibration						
		Wave/Twist in Tube				Fit/Function		Out of Sequence							

Work Ord June-03-14 7:1		20028	T	*120			··.			Page 8		
Item ID: Revision ID:	D3391-025	1		Accept	*N900	040	100	)*	Setup			S1*
Item Name:	Aft Tube As	sembly								Stop	*N	S2*
Start Date: Required Date:	6/03/14 <b>:</b> 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00		*  *	Cust Item Customer:	ID:						
Reference:			en en en en en en en en en en en en en e									
Approvals:	Process P	lan:	_ Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
260		•		0.00					,	<i>r</i>	. 1.	, 1
*260* HandFinish		HandFinishing		0.00			1	<u>(</u>		<u>,                                    </u>	YI ,	1117
Hand Finishing		2-Install Aft A/ R Sikafl Sikafle	erts as per Dwg D t Cap as per Dwg E lex-241/-291 <u>LL</u> ex expiry date: L WEARPLATES	03391 \30727   \$108					-			•
270		QC5- Inspect part compl	leteness to step on	W/O 0.00								DAS <b>38</b>
*270*								)				<b>9-8</b> 9
QC Quality Control		Memo		0.00					America de la composition della composition dell			14-12-0
280		Identify as per dwg & St	ock Location: W	10 0.00 Dulls	-742-043/1	31264	17)	•		/	Ul (	1.1
*280* Packaging		Memo		0.00	. 10	0.207			<u>-</u> 4	/	46 1	410105

Memo

Packaging

DQA:			Date:						_					TRAC"
						WORK ORDER NON	-CC	ONFO	RMANCE / UF		/l. Od	ا براسم معملي	_	AEROSPACE
QA Closed:			Date:							w	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work ora	••••			*		Rework	1		Skid-tube	Crosstube	7	Water Jet	$\Box$	Engineering
Part N	No.					Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	┨	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR I	۱o۰			-		Suspected Unapproved	]		Large Fab	Composite	]	Supplier		
Root		· · · · · · · · · · · · · · · · · · ·			Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	<u>1</u>	QC Inspector
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Material													1	
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Unapproved					<u> </u>		<u> </u>							
							FA	ULT CAT	<b>TEGORY</b>					
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		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under		-	Set-up
	-	Cracks			_	Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorred		_	Temperature/Cure
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs		4 '	ion Incomplete/Ur	· —	Part Lost/Mi	ssing	-	Weld
	-	Cuffs				Contamination	_	4	tions Incomplete/U	Jnclear	Part Moved			Wrong Stock Pulled
	$\vdash$	Crushing				Countersink	_	-	gned/off center	ļ	Positioned V	1		1
	$\vdash$	Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube	<u></u>	Drawing	$\vdash$	Misread						
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of	Seauence						

Work Ord June-03-14 7:1		20028		*120					Page	; 9			
Item ID: Revision ID: Item Name:	D3391-025			Accept	*N900	040	100	)*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	ID:						. 12	
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:			Run	Start Stop	^IVI	R1*	
	QC:	,	Date:	_ SPC (Y/N):	D:	ate:				•	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Nµmber	Insp. Stamp	
290 *290*		QC21- Final Inspection	Work Order Release	0.00						14	1121	19 H	
QC Memo				0.00	•							- <del> </del>	-

JA 1-12-09

DQA:			Date:				TRAGE						
						WORK ORDER NON	-CC	ONFOR	RMANCE / U			<b></b>	AEROSPACE
QA Closed:			Date:							V	Vork Order up	odate only	
Work Orde	or.				ı	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Ordi					_	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap	1 1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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NCR I	lo.					Suspected Unapproved	]		Large Fab	Composite		Supplier	
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Root					Desc	ription of work order update		nitial	ł	tion	Sign &	_	·
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Unapproved			<u> </u>			· <u></u> :	FΔ	III T CAT	TEGORY				
Landi	ng (	iear				General		OLI CA	LOOKI		<u></u>		
Lanc		Bending			<u> </u>	Bend		leolio/P	Program	Г	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	-	Grain		ľ	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire	-	Part Incorre	ci	Temperature/Cure
	_		nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	ngualified	Part Lost/M	issing	Weld
	Crimp/Kink/Ripple/Wave Cuffs			Contamination		-i	tions Incomplete/	· · · ·	Part Moved	Ī	Wrong Stock Pulled		
	-	Crushing				Countersink		Misalig	gned/off center	Γ	Positioned \	Wrong _	
	_	Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss,	/Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d	_			
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube			e		Fit/Function		Out of					

Picklist Print	-												P
June-03-14 7:12:0.	5 AM												
Work Order ID: 12	20028		*	1200	28*								
Parent Item: D	3391-025				1-025*	•							
Parent Item Name:	Aft Tube Assembly				1-(1/.)			S	Start Date: 6/0	3/14	Requir	ed Date:	6/03/14
								!	Start Qty: 1.0	0	Requi	red Qty:	1.00
Comments:	IPP Rev B 06-02 IPP Rev:C 06-03 IPP rev D 07.03 IPP rev E 07.11 IPP Rev:F 07-11 IPP Rev:G 08-09- 11.11.14 AS PER R	3-28 Update M: 3.20 revF dwg .07 rev G dwg -13 ECN 1056 10 revH as per dv	ecn 10  i g DI	nstructions EC 053p EC DD verified D verified by	JLM verified by: DD id by: EC v:EC IPP Rev								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issue	
D4095-047		Manufactured	No			260	Each	14.0000	1	1		. ^	,
*D4095-0	147*								<b>**</b>	120523	(1)	Jel	14
				Locatio	<u>on</u>	Loc	<u>Oty</u>	Loc Code					
			-	FP001	<b>*</b>		14		<del>.</del>				
					102241		2		_				
D4095-049		Manufactured	No		108289	260	12 Each	9.0000	 1	1	-		
*D4095-(	)49*	Wanulactured				200	Lucii	2.5000	**	B120	195	(x)	Ill
				Locatio	<u>on</u>	Loc	<u>Oty</u>	Loc Code					
				FP001			9				•		
D < 0.4 4 0.00					109670		9		_				
D6014-090		Manufactured	No			100	Each	63.0000	1	1			

\*D6014-090\*
ALUMINUM EXTRUSION

**Location**? LG003

63 17 86063 46

Loc Qty

\_\_\_\_\_ nm.b 14/08/18

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Loc Code

Page 1

Status

DQA:			Date:										TRACT			
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:						·	W	ork Order up	date only				
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS				
Work Orac						Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	۱o.					Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	•					Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other			
NCR N	۱o.					Suspected Unapproved	]		Large Fab	Composite	]	Supplier				
Root					Desc	ription of work order update	Ti	nitial	Act	ion	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector			
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		<del></del>		4	<del>/</del>	· · · · · · · · · · · · · · · · · · ·	FA	ULT CAT	FEGORY							
Landi	ng (	Sear				General		_			_	_	<del></del>			
:		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced			
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	ire	L	Part Incorre	_	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld			
		Cuffs				Contamination		4	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		-1	ned/off center		Positioned V	· ·	<b>_</b>			
	Heat Treat		<u> </u>	Cut Too Short		Mislabe		L	Power Loss/	Surge	Other					
	_	Inspection	1.5	Tube		Drawing	_	Misread								
	_	Marks/Ch			<u> </u>	Drill Holes	$\vdash$	Off-set			•					
	Turning Sequence				Finish		4	Calibration								
		Wave/Twist in Tube				Fit/Function		Out of S	Sequence							

June-03-14 7:12:05 AM

Work Order ID: 120028

\*120028\*

Parent Item:

D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

**Start Date:** 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured

230

Each

232.0000

Loc Code

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\*D3670-4-200\*

Bushing

Location Loc Oty FG 10 87709 10 LG001 222 103880 15 109108 206 96240 1

D2646

Aft Cap

Manufactured

270 Each

62.0000

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Location	]	Loc Qty	Loc Code	
FG		4	B119656	<u> </u>
858	348	2	01116	,
904	95	2	`	
FP001		58		
103	306	3		
107	857	1		
110	816	13		
113	830	31		
114	495	10		

DQA:			Date:			•							`	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI			_		AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	· ·		-			DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
WOIK OIGE	-					Rework			Skid-tube	Crosstube	1	Water Jet	$\neg$	Engineering
Part N	In					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	$\dashv$	Quality
raici	•0				<del></del>	Use-as-is			noforming	Finishing	4	e/Packaging	$\exists$	Other
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite	1 '	Supplier	$\Box$	
										· <u></u>			_	
Root					Desc	ription of work order update	I	nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	<u>n</u>	QC Inspector
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Operator	$\Box$		:											
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····						<u>,</u>	FAI	ULT CAT	regory			<u> </u>		
Landir	ng G	iear				General		•		_	7	ı	_	
		Bending				Bend	_	•	rogram		Outside Dim		-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under		$\vdash$	Set-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa	ire	L	Part Incorred	લ	ш	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified	Part Lost/Mi	ssing	$\boldsymbol{\vdash}$	Weld
		Cuffs				Contamination		4	tions Incomplete/l	Jnclear	Part Moved		∖∐	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V			
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d .					
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of 0	Calibration			<u></u>		
				Fit/Function		Out of Sequence								

Picklist Print June-03-14 7:12:05 AM									Page 3
Work Order ID: 120028	*10	0000*					- 16 - 74 - 14 - 15 - 14		
Parent Item: D3391-025		0028*		•					
Parent Item Name: Aft Tube Assembly	<b>~1</b> )(3	391-025*			C.		100.11.4	<b>.</b>	
Tatent Item Name. All Tube Assembly						rt Date: 6 art Qty: 1		-	Date: 6/03/14 d Qty: 1.00
D3672-1 Manufactured	No		270	Each	1,238.000	2	2		
*D3672-1* Phenolic Washer						**		_W_	While
		<b>Location</b>	<u>L</u>	oc Oty	Loc Code				
		FG		10					
		85222		10				<del>-</del>	
		Return2014		34					
		80369		34				<del>_</del>	
	;	ST060		1194				_	
		103845		4				_	
		112218		500				-	
		. <u>113581</u> 93886		500 62			<u> </u>	_	
		99099		128				_	
ALS4-1032-130 AELS4-1032-130 Purchased	No		260	Each	7,504.000	14	14	~	
*AI S4-1032-130*					;	<b>k*</b>		Jel	14/11/17
•	<u>]</u>	Location	Lo	c Oty	Loc Code				
	]	FP001		7399					
		M128649		7399			<u> </u>	<del></del>	
•		ST279		48				_	

June-03-14 7:12:05 AM

48

57 57

st510

M128211

M126109

DQA: Date:					WORK ORDER NON		DART					
QA Closed:		Date	:		WORK ORDER NON	-((	JINFUI	RIVIANCE / UPDATE	W	ork Order up	date only	AEROSPACE
Work Orde	ar.	-			DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstu Machining Small F noforming Finishi Large Fab Compos	ab ng	-1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update	ı	nitial	Action		Sign &	<del></del>	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						FAI	ULT CA	FEGORY				
Landir	og Goor					FA	OLI CA	IEGURT	-			
Landir	Landing Gear  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
ţ	Wave/Twist in Tube			Fit/Function	$\vdash$	Out of Sequence						

June-03-14 7:12:05 AM

Work Order ID: 120028

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

ALS4-1032-225

AELS8-1032-225 Purchased

\*AI S4-1032-225\* ⊀

Rivnut

\*120028\* \*D3391-025\*

No

**Start Date:** 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

727.0000 8

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Locatio	<u>on</u>	Loc Qty	Loc Code	•
FG		30		
	M127028	30	11130565	
FP001		423		
	M128649	423		
ST280		248		
	M127028	10		<del></del>
	M128179	238		
st555		26		
	M127092	26		

Each

270

DQA:			Date:		<del></del>	WORK ORDER NON	<i>CC</i>	SNIFOI		IDDATE					
QA Closed:			Date:			WORK ORDER NON	-C(	JNFOI	KIVIAINCE / C		Nor	k Order up	date only	Γ	AEROSPACE
						DISPOSITION				AGAINST D		· · · · · · · · · · · · · · · · · · ·	<u> </u>		
Work Orde	er:					Disrosition	. 1			AOAMS1 E	, —	A		_	, <del>, , ,</del>
						Rework			Skid-tube	Crosstube	4	_	Water Jet	<u> </u>	Engineering
Part N	No.					Scrap			Machining	Small Fab	4		d. Eng. Coor.	$\vdash$	Quality Other
NCR I	J.					Use-as-is Suspected Unapproved		Inern	noforming Large Fab	Finishing Composite	$\dashv$	Rec/Stor	e/Packaging Supplier		Other
NCK	١٥.					Suspected Oliappioved	1		Large rab	composite			Supplier		l — I
Root					Desc	ription of work order update		nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verificatio	n	QC Inspector
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	<u> </u>	Cracks				Broken/Damage/Defect	_	Hardwa		-		Part Incorred		⊢	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave		Burrs		1 '	ion Incomplete/	· · · · · · · · · · · · · · · · · · ·		Part Lost/Mi	ssing	<u> </u>	Weld
		Cuffs				Contamination		4	tions Incomplete	<u>-</u>	_	Part Moved			Wrong Stock Pulled
	<u> </u>	Crushing			<u> </u>	Countersink	<u></u>	4	gned/off center	r	_	Positioned V	_	_	1
		Heat Trea			<u> </u>	Cut Too Short	_	Mislabe		L		Power Loss/	Surge	$ldsymbol{le}}}}}}}$	Other
	Inspection Strip in Tube				L	Drawing	_	Misrea			_				
	Marks/Chatter					Drill Holes		Off-set			_			_	
	Turning Sequence					Finish	Out of Calibration								
	Wave/Twist in Tube					Fit/Function		Out of	Sequence						

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Picklist Print June-03-14 7:12:05 AM		;						Page 5
Work Order ID: 120028	MI (MAI)	*1	20028	*				+
Parent Item: D3391-025 Parent Item Name: Aft Tube As	sembly		)3391-			Start Date: Start Qty:		Required Date: 6/03/14 Required Qty: 1.00
AN3C4A	Purchased	No		2	70 Each	2,750.000 6	6	
*AN3C4A*						**		Il relicher
			Location		Loc Oty	Loc Code		
			FG 122	2814	20 20	M130716		<u>.</u>
			Return2014		9			<u> </u>
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			ST350		13		-	<u> </u>
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				1221	3			and the same of th
			ST513		2679			<del></del>
				27410	1			<del></del>
				27832	62			
			M1	28634	616			
			M1	28879	2000			<u> </u>
AN3C5A	Purchased	No		21	70 Each	991.0000 4	4	A 6 1
*AN3C5A*						**	<del></del>	dl 14/4/17
			<b>Location</b>		Loc Oty	Loc Code		
			FG		5			
			122	2800	5	M 130358	X 7	<u> </u>
			ST350		386		<del> </del>	<del></del>
				28973	186			
				29198	200			
			ST513		600			<u> </u>
			<b>M</b> 1	28911	600			<del>_</del>
June-03-14 7:12:05 AM				Shop Packet	Print			Page 5

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DQA:		_ Date:											TRAG
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE	Wa	ork Order up	odate only	AEROSPACE
Q, Closeu.		Dute.									PARTMENT	· · · · · · · · · · · · · · · · · · ·	
Work Orde	r:				DISPOSITION	١							
	-				Rework			Skid-tube	Crosstube	_	Dwa	Water Jet	Engineering
Part N					Scrap	1 1		Machining	Small Fab Finishing	_		d. Eng. Coor. re/Packaging	Quality Other
NCR N	lo				Use-as-is Suspected Unapproved		Thermoforming Fi Large Fab Con				Nec/3to	Supplier	
Root		ł		Desci	ription of work order update		nitial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
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Doc/Data								ļ			·		
Equip/Tooling								1					
Handling/Pre													
Material													
Operator	_												
Offset/Setup	_			:									
Process								3					
Supplier	_												
Training													
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Unapproved		<u> </u>		<u> </u>				<u> </u>				<u> </u>	
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Landin	ng Gear				General		1				1		٦
Ļ	Bending			<u> </u>	Bend		•	Program		<u> </u>	Outside Dim	<b>⊢</b>	Pressure/Forced
	_	lot Conce	ntric	<u> </u>	BOM/Route		Grain			_	Over/Under	<b>-</b>	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorre	-	Temperature/Cure
1		ink/Ripple	e/Wave		Burrs	_	4 '	ion Incomplete/Ur			Part Lost/Mi	issing	Weld
	Cuffs			$\perp$	Contamination		4	tions Incomplete/U	Jnclear	<u> </u>	Part Moved		Wrong Stock Pulled
}.	Crushing				Countersink	$\vdash$	1 '	gned/off center		L	Positioned V		
}	Heat Treat				Cut Too Short		Mislab			<u></u>	Power Loss/	Surge _	Other
}	Inspection Strip in Tube				Drawing		Misrea						<del></del>
}	Marks/Chatter				Drill Holes	$\vdash$	Off-set					<del></del>	
ļ.	Turning Sequence				Finish	Out of Calibration				<u> </u>	-		
	Wave/Twist in Tube				Fit/Function		Out of	Sequence					

## **Picklist Print**

June-03-14 7:12:05 AM

Page 6

Work Order ID: 120028

D3391-025

Parent Item Name: Aft Tube Assembly

\*120028\* \*D3391-025\*

**Start Date:** 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

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Required Qty: 1.00

relul, 7

NAS1149C0332R

**Parent Item:** 

Purchased

No

270

Each

5,404.000

10 10

\*NAS1149C0332R\*

Location		Loc Oty	Loc Code	
GA		825	M 130375	
1	25654	825	1/1/10/202	O 1x
Return2014	ļ.	41		
1	22063	41		
ST292		1380		
1	24580	8		
1	25654	8		
m	128591	1364		
st510		3158		
m	1126319	61		
m	1127306	2500		
m	127410	563		
m	127831	34		

DQA:			Date:	···-		WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NOW			WANCE / OF DA		ork Order up	date only	AEROSPACE			
Work Orde	r:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS				
Part N	lo				_	Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstub  Machining Small Fa  Thermoforming Finishin  Large Fab Composit			4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector			
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, (-)	Turning Sequence Wave/Twist in Tube					Finish Fit/Function	-	1	Calibration Sequence			<u> </u>				

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DART AEROSPACE LTD	Work Order:	120028
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Lat	he Section	1		
14.000	+/-0.010	14.00			tape	L G-11
3.500	+/-0.010	3.499	_		Wern	CNC-08
Ø3.200	+/-0.010	3.201	_		1	
Ø3.750	+/-0.010	3.750			<b>\</b>	
30° x 0.060 chamfer	+/-0.010	30° X ,060	-			
88.93	+/-0.030	88.940			tape	46-11

Measured by: Date: 14/08/17

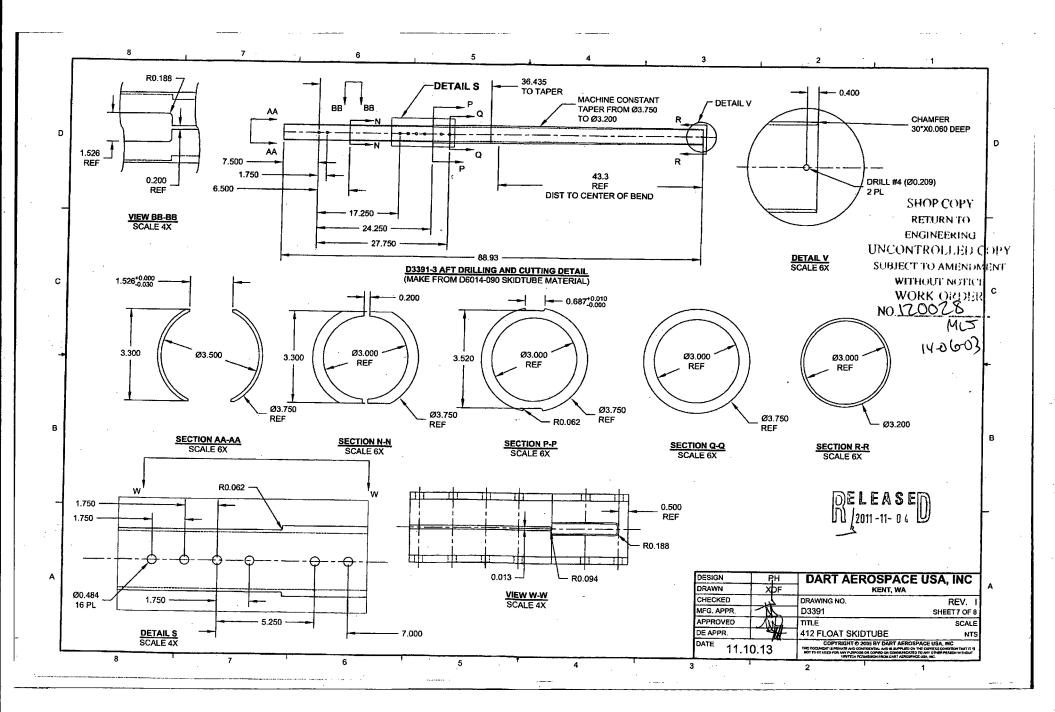
Audited by: Date: 14/17-10

	HAAS Section												
1.526	+0.000/-0.030	1.510	Vericucor										
7.500	+/-0.010	7495	U										
27.750	+/-0.010	27.749	Haas I										
31.750	+/-0.010	31.750											
35.250	+/-0.010	35.245	V										
3.300	+/-0.010	3.298	Vern encor										
0.200	+/-0.010	.197	)										
3.520	+/-0.010	3.522											
0.687	+0.010/-0.000	.688											
R0.062	+/-0.010	0062											
Ø0.484	+0.005/-0.001	.484											

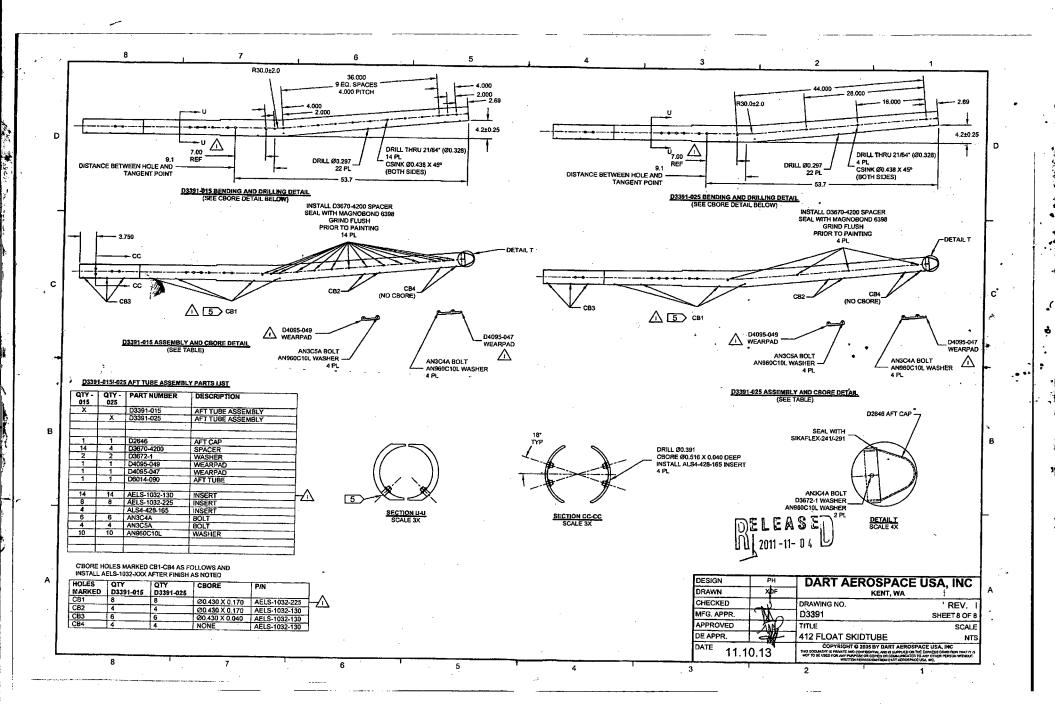
Measured by: PH/D/12 Date: Date: Jul 10/12 Dat

Rev	Date	Change	Revised by	Approved
Α	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
В	06.06.19	Dwg revision update	KJ/JLM	
С	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
Е	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
ı	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ M	<u> </u>
Ĺ	12.11.28	88.93 dimension added	KJ 😽	<b>^</b>

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WOIK OIG	- '				-	Rework	ıl		Skid-tube	Crosstube	7	Water Jet	Engineering				
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	-		-		_	Use-as-is	1 1		noforming	Finishing	<b>-</b> 1	re/Packaging	Other				
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	Cuffs				Contamination	<u> </u>	4	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled					
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		Heat Trea				Cut Too Short	<u></u>	Mislabe			Power Loss/	Surge	Other				
	_	Inspection		Tube		Drawing	<u></u>	Misrea				· .					
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Wave/Twist in Tube					Fit/Function		Out of	Sequence									



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Offset/Setup													- -	
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		Bending		**		Bend		Folio/P	rogram		-	Outside Dim	_	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			—	Over/Under	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa			$\dashv$	Part Incorred	<u> </u>	Temperature/Cure
•		Crimp/Kin	ık/Ripple	/Wave		Burrs	$oxed{oxed}$	1 '	ion Incomplete/U	· ·	$\dashv$	Part Lost/Mi	ssing	Weld
•		Cuffs		etions.		Contamination	_	₹	ions Incomplete/	Unclear		Part Moved	L	Wrong Stock Pulled
	Crushing				<u> </u>	Countersink		4 *	ned/off center		-	Positioned V		ا " ا
*	Heat Treat				<u> </u>	Cut Too Short	<u>_</u>	Mislabe		Į		Power Loss/	Surge	Other
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	Marks/Chatter					Drill Holes		Off-set						
	Turning Sequence					Finish	Out of Calibration							
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	Crimp/Kinl Cuffs	k/Ripple	/Wave	,	Burrs Contamination	4	Inspection Incomplete/Unqualified Instructions Incomplete/Unclear	Part Lost/Missing Part Moved	Weld Wrong Stock Pulled
-	Crushing		10	-	Countersink		Misaligned/off center	Positioned Wrong	
	Heat Treat	î:	-		Cut Too Short	U.V., TV	Mislabeled	Power Loss/Surge	Other
\$2	Inspection	Strip in	Tube		Drawing		Misread		
٠.	Marks/Cha				Drill Holes '	. ~ .	Off-set		1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
	Turning Se			_	Finish		Out of Calibration		
ا را	Wave/Twi	st in Tub	e e		Fit/Function		Out of Sequence		